

SPLIT

Work Order ID 59934 - 2

Thursday, June 17, 2010 12:56:44 PM

Page 1

Item ID: D2962-150

Accept

Revision ID:

Item Name: 3.540 Outer Tube, Extrud

70 C/L 10/6/21

Start Date: 6/17/2010 Start Qty: 40.00

Required Date: 6/24/2010 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 10-6-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2962

Rev A

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 12127 a) Extrude as per Dwg D2962 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 125" long g) Bon L Canada Inc. tool #

C/L 10/6/21 (70)

110

0.00



Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Packaging

Ensure material certification is attached

C/L 10/8/17 (45)

120

0.00



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

Check Pull test per Dwg D2962 for compliance page attached. Check hardness with Webster tester

control (45)

+ Puller Qty 10 pcs + inspection
100% per Dwg - 8/10/24 (70)

Work Order ID 59934

Thursday, June 17, 2010 12:56:44 PM



Page 2

Item ID: D2962-150

Accept



Setup Start



Revision ID:

Item Name: 3.540 Outer Tube, Extrud

Stop



Start Date: 6/17/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: BackHau 0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

45 10/08/24

10/08/25
c210/8/25

Picklist Print

Thursday, June 17, 2010 12:56:48 PM

Page 1

Work Order ID: 59934



Parent Item: D2962-150



Parent Item Name: 3,540 Outer Tube, Extrut



Start Date: 6/17/2010

Required Date: 6/24/2010

Start Qty: 40.00

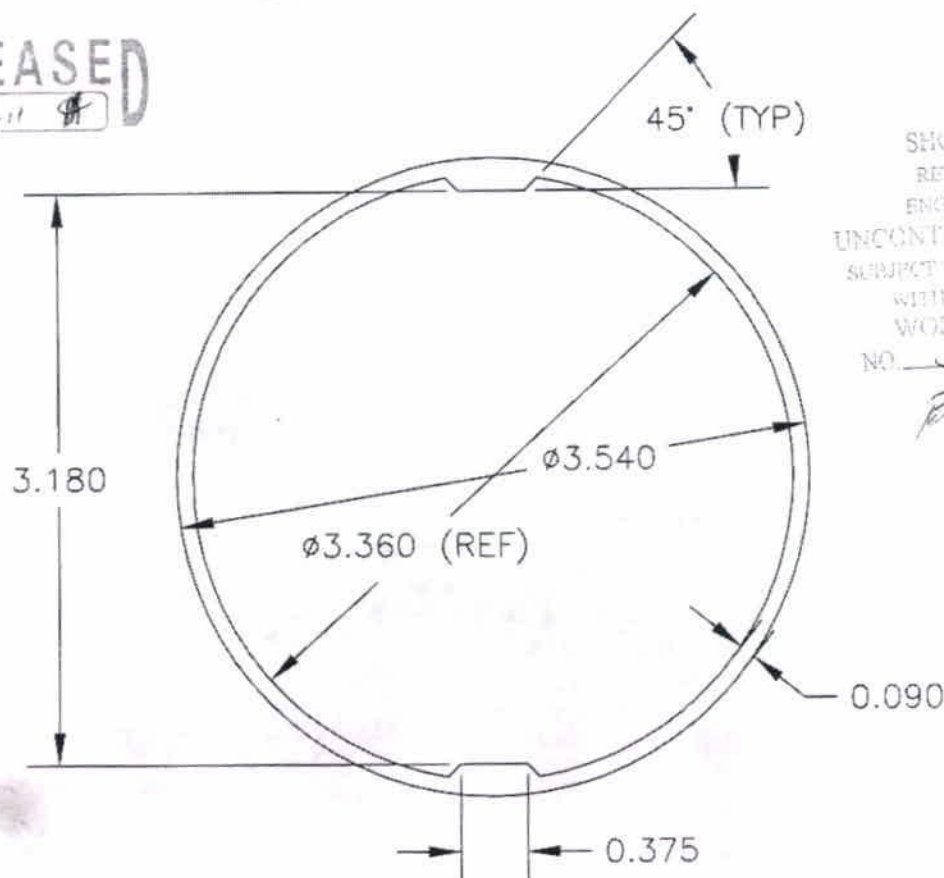
Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150P  3,540 Outer Tube, Extrut		Purchased	No			110	Each	0.0000	1 	40		02/08/17	(45)

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED 	APPROVED 	DRAWING NO. D2962	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE EXTRUSION	SCALE 1:1
A	00.03.10	NEW ISSUE	

RELEASED
00-05-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59934
PS 10-6-17

GENERAL NOTES

1. MANUFACTURED USING BON L CANADA DIE # T80- DAA-897127
2. ORDER AS D2962-XXX WHERE XXX = LENGTH IN INCHES
EG. 125 LONG: D2962-125
3. MATERIAL: 6061-T6 (QQ-A-200/8)
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

4. BREAK ALL UNMARKED SHARP CORNERS 0.016-0.025
5. NO TOOLING MARKS.
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
7. ALL DIMENSIONS ARE IN INCHES.

Copyright © 2000 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

MANIFEST DATE	08-14-10
MANIFEST NUMBER	682615
SALES ORDER NUMBER	64085

ACCT# 00046024

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
--	--

TERMS / FREIGHT O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

CREDIT REP DHILLON, ROBE	SALES REP
-----------------------------	-----------

LOCATION PIC	TRAILER NUMBER 20934	SALESMAN 59358	FIELD SALES REP Bates M 905-427-2235	CUST SERVICE REP Burton D 905-427-2227
-----------------	-------------------------	-------------------	--	--

CUSTOMER ID 46024	ORDER DATE 06/21/10	CUSTOMER PO NUMBER 12127	JOB	BILL OF LADING NUMBER 08409807
----------------------	------------------------	-----------------------------	-----	-----------------------------------

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER LENGTH CUTTING TOLERANCE	FINISH DESCRIPTION FABRICATION DESCRIPTION SHIPPING TOLERANCE	THIS SHIPMENT			UNIT	QUANTITY DUE
							NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
01	1105	LB	439	DAA-3-2	6061 /T6	MILL	2	730	690	LB	0
	875	FT	349	D2962150	150"	CERTIFICATE OF COMP			562.49	FT	0
	70	PC	28		+5/16 " -0 "	(+015-015,0048-0035)			45	PC	0
LOT/TKT DETAIL:						6408501 / 365374	1	452	432		28 PC
						6408501 / 365375	1	278	258		17 PC
							TOTALS				
							2	730	690	LB	
									562.49	FT	
									45	PC	

CX101817
Rex'd 45

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
08/14/10	208854	64085	1
Cert ID	B/L No	Lot	Date
12127	08409807	64085010	8/14/10

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.001	DAA-3-2	150" MILL 6061 T6	02962150
Gross Weight	730 LBS		
Net Qty	690 LB	45 PC	563 FT 2 PKG
Specification	AMS-QQ-A-200/8 & ASTM B221-08		
	Die Desc		

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	302.9 / 44.0	273.6 / 39.7	9.9	.0	91
2	292.4 / 42.4	262.9 / 38.2	10.6	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.64	.29	.24	.05	.88	.06	.08	.01
.65	.29	.25	.05	.90	.06	.18	.01

S. Soler

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Ryan Petersen, QA Manager Signature Aluminum Canada Inc